

Print
Work Order ID 66891-2

Wednesday, March 02, 2011 10:11:29 AM



Page 1

Item ID: D3243-041

Accept



Setup

Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 3/2/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: *WME*

Date: 11-03-02 Tooling:

Date:

Run

Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3243	Rev A
-------	-------

110



Waterjet

FLOW CNC Waterjet

6061 - 063

HAAS CNC VERTICAL MACHINING #1

Memo

1-Cut as per Dwg
Dwg Rev: *A*
Prog Rev: *A*

2-Deburr if necessary

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B11-3-3

B11-3-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66891

Wednesday, March 02, 2011 10:11:29 AM



Page 2

Item ID: D3243-041

Accept



Setup Start



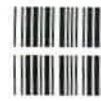
Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 3/2/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

ml 11 03 03 10

150



Brake NC

NC BRAKE

0.00

SD 11/03/01

10

Brake NC

Memo

0.00

Form as per Dwg D3243

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SD 11/03/04

+16

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 66891

Wednesday, March 02, 2011 10:11:29 AM



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Item ID: D3243-041

Accept



Setup

Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 3/2/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170



HandFinish

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp170
HandFinish
Hand Finishing

Memo

0.00

10 62 11-3-7.

180



Small Fab

Small Fab

0.00

E.Su/03/10 ①

Small Fab

Memo

0.00

Small Fab
Install Inserts as per Dwg D3343

190



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

M 11 03 10 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 66891

Wednesday, March 02, 2011 10:11:29 AM



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Item ID: D3243-041

Accept



Setup Start



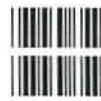
Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 3/2/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

200



Powdercoat

Powder Coating

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M112588

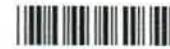
Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

4

BL 11-3-15

10:45
3200
11:15

220



Packaging

Packaging

Identify as per dwg & Stock Location. 227

0.00

Memo

0.00

4

6 14 1103/15

113/15 805

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 66891

Wednesday, March 02, 2011 10:11:29 AM



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Item ID: D3243-041

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Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 3/2/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

230

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC

Quality Control

Memo

0.00

11/3/10

MF

11-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 02, 2011 10:11:26 AM

Page 1

Work Order ID: 66891



Parent Item: D3243-041



Parent Item Name: Bracket Assembly

Start Date: 3/2/2011

Required Date: 3/23/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-032-EF  Inserts		Purchased	No			180	Each	26.0000	4	20	<i>E/S 11/03/10</i>		
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST285			26						
				110836			26						
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			110	sf	145.5000	0.5499	2.894211	<i>211</i>	<i>411-3-3</i>	<i>6.</i>
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				MAT			111.6						
				116308			28.6						
				116623			83						
				MAT21			33.9						
				113608			33.9						

W/O:		WORK ORDER CHANGES					
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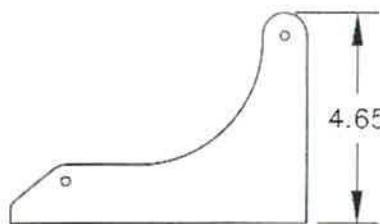
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3243	SHEET 1 OF 1
DATE	TITLE	SCALE	
04.01.09	BRACKET	1:2	
A	04.01.09	NEW ISSUE	



6689/
INSTALL
FE-032-EF INSERTS
(4 PLACES)



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

RELEASED
04.02.03

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D3243-1
FLAT PATTERN**

6.560 5.810 5.360 R2.75 (TYP)
R0.50 (TYP) 0.500 0.000
0.750 0.500 0.000

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	66891
Description: Bracket	Part Number:	D3243-1
Inspection Dwg: D3243	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: <u>B</u>	Audited by: <u>M. M.</u>	Prototype Approval:	N/A
Date: <u>11-3-03</u>	Date: <u>1103-03</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.18	New Issue (P/O D044-715-011)	KJ/JLM	
B	04.04.19	Removed dimensions from FAI	KJ/RF	TT

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